IN THE CLAIMS:

Please amend claims 1-10 as follows.

1. (Currently Amended) A method of manufacturing an outer race member for a tripod-type constant-velocity joint having a shank and a cup which are integrally formed by cold forging, comprising the steps of:

extruding forwards a cylindrical workpiece ~~(10)~~ cut to a predetermined length to form a primary formed body ~~(16)~~ having a shank ~~(14)~~;

preliminarily upsetting an upper portion ~~(18)~~ of said workpiece ~~(10)~~ except said shank ~~(14)~~ thereof to form a secondary formed body ~~(20)~~;

further upsetting an upper portion ~~(22)~~ of said secondary formed body ~~(20)~~ except said shank ~~(14)~~ thereof to form an intermediate preliminary formed body ~~(24)~~ having an annular slanted surface ~~(36)~~ which provides a material-flow resistance difference between larger-diameter portions ~~(28a through 28c)~~ and smaller-diameter portions ~~(30a through 30c)~~ thereof;

extruding backwards said intermediate preliminary formed body ~~(24)~~ to form a quaternary formed body ~~(58)~~ having a cup ~~(62)~~ with track grooves ~~(60a through 60c)~~ defined therein; and

ironing said cup ~~(62)~~ of said quaternary formed body ~~(58)~~.

2. (Currently Amended) A method according to claim 1, wherein said intermediate preliminary formed body ~~(24)~~ has a disk-shaped head ~~(26)~~ which is thinner and larger in diameter than said upper portion ~~(22)~~ of said secondary formed body ~~(20)~~,

said head ~~(26)~~ having, as viewed in plan, a plurality of larger-diameter portions ~~(28a through 28c)~~ projecting radially outwardly and angularly spaced a predetermined angle circumferentially, and a plurality of curved and recessed smaller-diameter portions ~~(30a through 30c)~~ each disposed between adjacent ones of said larger-diameter portions ~~(28a through 28c)~~.

3. (Currently Amended) A method according to claim 2, wherein said head ~~(26)~~ has on an upper end thereof an annular slanted surface ~~(36)~~ having a tilt angle with respect to a horizontal plane, said tilt angle varying continuously circumferentially.

4. (Currently Amended) A method according to claim 3, wherein said annular slanted surface ~~(36)~~ has a tilt angle α at said larger-diameter portions ~~(28a through 28c)~~ and a tilt angle β at said smaller-diameter portions ~~(30a through 30c)~~, said tilt angle β being greater than said tilt angle α to cause said larger-diameter portions ~~(28a through 28c)~~ and said smaller-diameter portions ~~(30a through 30c)~~ to have different amounts of backward plastic flow depending on a material-flow resistance difference between said larger-diameter portions ~~(28a through 28c)~~ and said smaller-diameter portions ~~(30a through 30c)~~ when said intermediate preliminary formed body ~~(24)~~ is extruded backwards in the next step.

5. (Currently Amended) A method according to claim 4, wherein the difference between the tilt angle α of said larger-diameter portions ~~(28a through 28c)~~ and the tilt

angle β of said smaller-diameter portions ~~(30a through 30c)~~ is in the range from 3 degrees to 12 degrees.

6. (Currently Amended) A method according to claim 3, wherein said annular slanted surface ~~(36)~~ has a radial width which is largest at the centers of said larger-diameter portions ~~(28a through 28c)~~ and smallest at the centers of said smaller-diameter portions ~~(30a through 30c)~~.

7. (Currently Amended) A method of manufacturing an outer race member for a tripod-type constant-velocity joint having a shank and a cup which are integrally formed by cold forging, comprising the steps of:

extruding forwards a cylindrical workpiece ~~(10)~~ cut to a predetermined length to form a primary formed body ~~(16)~~ having a shank ~~(14)~~;

preliminarily upsetting an upper portion ~~(18)~~ of said workpiece ~~(10)~~ except said shank ~~(14)~~ thereof to form a secondary formed body ~~(20)~~;

further upsetting an upper portion ~~(22)~~ of said secondary formed body ~~(20)~~ except said shank ~~(14)~~ thereof to form an intermediate preliminary formed body ~~(24a)~~ having an annular slanted surface ~~(36a)~~ which extends circumferentially along a plurality of larger-diameter portions ~~(28a through 28c)~~ and a plurality of smaller-diameter portions ~~(30a through 30c)~~ thereof and which provides a constant tilt angle in said larger-diameter portions ~~(28a through 28c)~~ and said smaller-diameter portions ~~(30a through 30c)~~ thereof;

extruding backwards said intermediate preliminary formed body ~~(24a)~~ to form a

quaternary formed body ~~(58)~~ having a cup ~~(62)~~ with track grooves ~~(60a through 60c)~~ defined therein; and

ironing said cup ~~(62)~~ of said quaternary formed body ~~(58)~~.

8. (Currently Amended) A method according to claim 7, wherein said intermediate preliminary formed body ~~(24a)~~ has a disk-shaped head ~~(26)~~ which is thinner and larger in diameter than said upper portion ~~(22)~~ of said secondary formed body ~~(20)~~, said head ~~(26)~~ having, as viewed in plan, a plurality of larger-diameter portions ~~(28a through 28c)~~ projecting radially outwardly and angularly spaced a predetermined angle circumferentially, and a plurality of curved and recessed smaller-diameter portions ~~(30a through 30c)~~ each disposed between adjacent ones of said larger-diameter portions ~~(28a through 28c)~~.

9. (Currently Amended) A method according to claim 8, wherein said head ~~(26)~~ has on an upper end thereof a circular flat surface ~~(33)~~ and an annular slanted surface ~~(36a)~~ extending around said circular flat surface ~~(33)~~ and having a constant tilt angle α with respect to a horizontal plane circumferentially along said larger-diameter portions ~~(28a through 28c)~~ and said smaller-diameter portions ~~(30a through 30c)~~.

10. (Currently Amended) A method according to claim 9, wherein the area of said annular slanted surface ~~(36a)~~ at said larger-diameter portions ~~(28a through 28c)~~ is

greater than the area of said annular slanted surface ~~(36a)~~ at said smaller-diameter portions ~~(30a through 30c)~~.